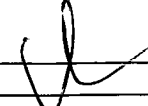



Date: Friday, 01/02/2008 9:49:56 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLANGE ASS'Y
 Job Number : 37142
 Estimate Number : 13032
 P.O. Number :
 This Issue : 01/02/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 36914
 Written By : 
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC
 Est Rev:B ECN 1113P 08-01-22 DD

Part Number : D3651043
 Drawing Number : D3651 REV.B U/R
 Project Number : N/A
 Drawing Revision : B U/R
 Material :
 Due Date : 08/02/2008 Qty: 2 Um: Each

08-03-07


Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.2573 sf(s)/Unit Total : 0.5145 sf(s)

304/316 SS sheet 26 ga (0.018" thick)

Batch: *106996 HB 8-2-4*

(FOR D3651-7)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3651 (D3651-7)

Dwg Rev: *PRE L B*

Prog Rev: *PRE L B HB 8-2-4*

2-Deburr if necessary

IDENTIFY AS D3651-7

HB 8-2-4

(2)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-2-4

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

D3651-7
08/02/08 *(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASS'Y

Job Number: 37142

Part Number: D3651043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M304S26GA

304/316 0.018 SHEET



Comment: Qty.: 0.2573 sf(s)/Unit Total: 0.5145 sf(s)

304/316 SS sheet 26 ga (0.018" thick)

Batch: 106946 B 8-2-4

(FOR D3651-5)

6.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3651 (D3651-5)

Dwg Rev: B B 8-2-4

Prog Rev: B B 8-2-4

2-Deburr if necessary

Identify as D3651-5 B 8-2-4

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

D3651-5
08/12/04 (2)

9.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form D3651-5 and D3651-7 as per Dwg D3651

08.03.12

PTD

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-03-13

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3651

PD 08-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3651-043 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: JD Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

NCR: 37142		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/19	# 9.0	One D3651-51-7 Scraped	<u>JD</u> 08/03/19	Destroy	<u>JD</u> 08/03/19	<u>JD</u> 08/03/14	<u>JD</u> 08/03/14	<u>JD</u> 08/03/14

NOTE: Date & initial all entries

Date: Friday, 01/02/2008 9:49:56 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASSY

Job Number: 37142

Part Number: D3651043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12/08/03/13

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/08/03/13 (1)

14.0

D36513

BASE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
BASE

B37165

15.0

MS20427M33

Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)
Rivet

M106993

16.0

MS210603K

Nut Plate



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
Nut Plate

M105938

17.0

CR352340

RIVET



Comment: Qty.: 57.0000 Each(s)/Unit Total : 114.0000 Each(s)
RIVET

M106302

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D3651

12/08/03/13

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/01/03/17

ENGINEERING
APPROVAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/02/2008 9:49:56 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASS'Y

Job Number: 37142

Part Number: D3651043

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: P00 38103

12/3/18 (1)

(12)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



080318

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

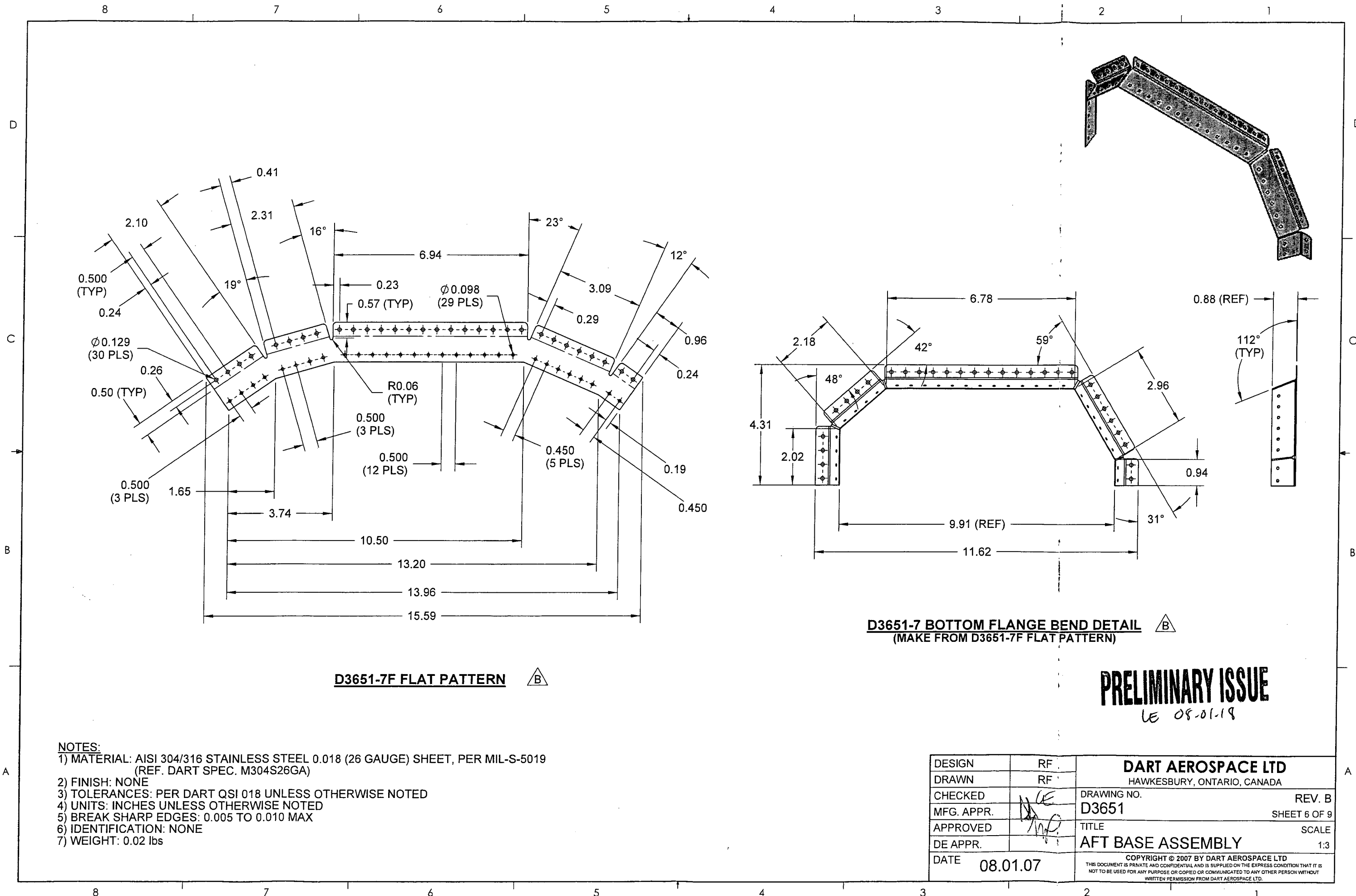


12 0803-14

POSITIVE RECALL

EFFECTIVE 080201 AUTH 11

RELEASED PU DATE 080308



D3651-7F FLAT PATTERN B

D3651-7 BOTTOM FLANGE BEND DETAIL B
(MAKE FROM D3651-7F FLAT PATTERN)

PRELIMINARY ISSUE
LE 08-01-19

- NOTES:**
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	MD	D3651	SHEET 6 OF 9
APPROVED		TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:3
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

TRANSFER DRILL Ø0.129 (#30 DRILL)
FROM D3651-5/-7 TO D3651-3
INSTALL CR3523-4-02 OR NAS9307M-4-02
RIVETS (57)

MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

GTAW
GRIND FLAT TO
CLEAR FASTENERS
(2 PLACES)

D3651-5
TOP FLANGE
(REF)

D3651-7
BOTTOM FLANGE
(REF)

D3651-3
BASE

D3651-043 FLANGE WELDMENT

QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NAS9307M-4-02	RIVET

PRELIMINARY ISSUE
LE 08-01-18

- D3651-043 NOTES:**
1) WELD PER QSI 004
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.76 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	NAO	D3651	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:3
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TRANSFER DRILL $\phi 0.129$ (#30 DRILL)
FROM D3651-5/-7 TO D3651-3
INSTALL CR3523-4-02 OR NAS9307M-4-02
RIVETS (57)

MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

G
GTAW
GRIND FLAT TO
CLEAR FASTENERS
(2 PLACES)

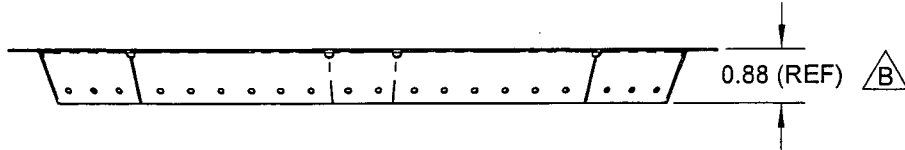
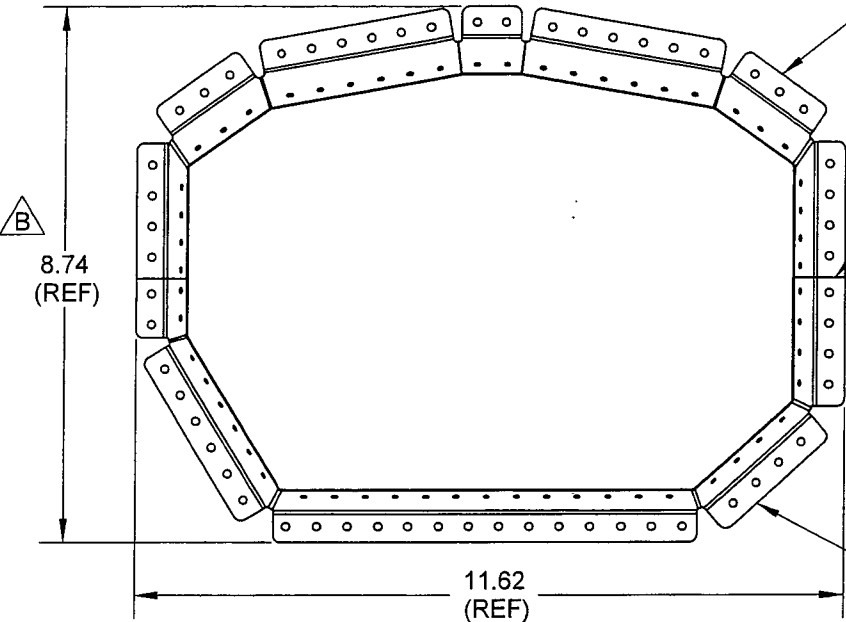
D3651-5 TOP FLANGE

D3651-7 BOTTOM FLANGE

D3651-5
TOP FLANGE
(REF)

D3651-7
BOTTOM FLANGE
(REF)

D3651-3
BASE

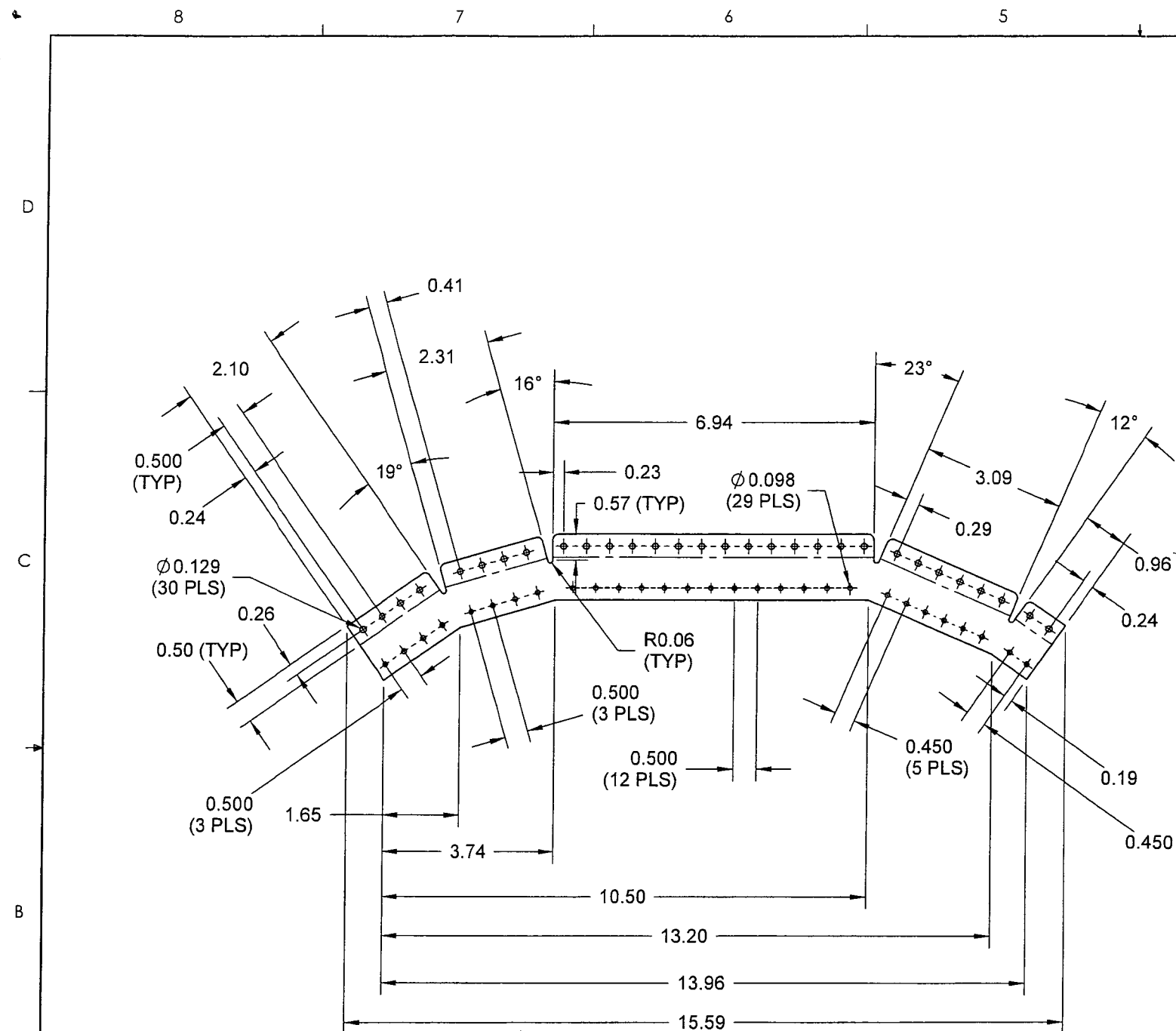


D3651-043 FLANGE WELDMENT

QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NA9307M-4-02	RIVET

- D3651-043 NOTES:
- 1) WELD PER QSI 004
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.76 lbs

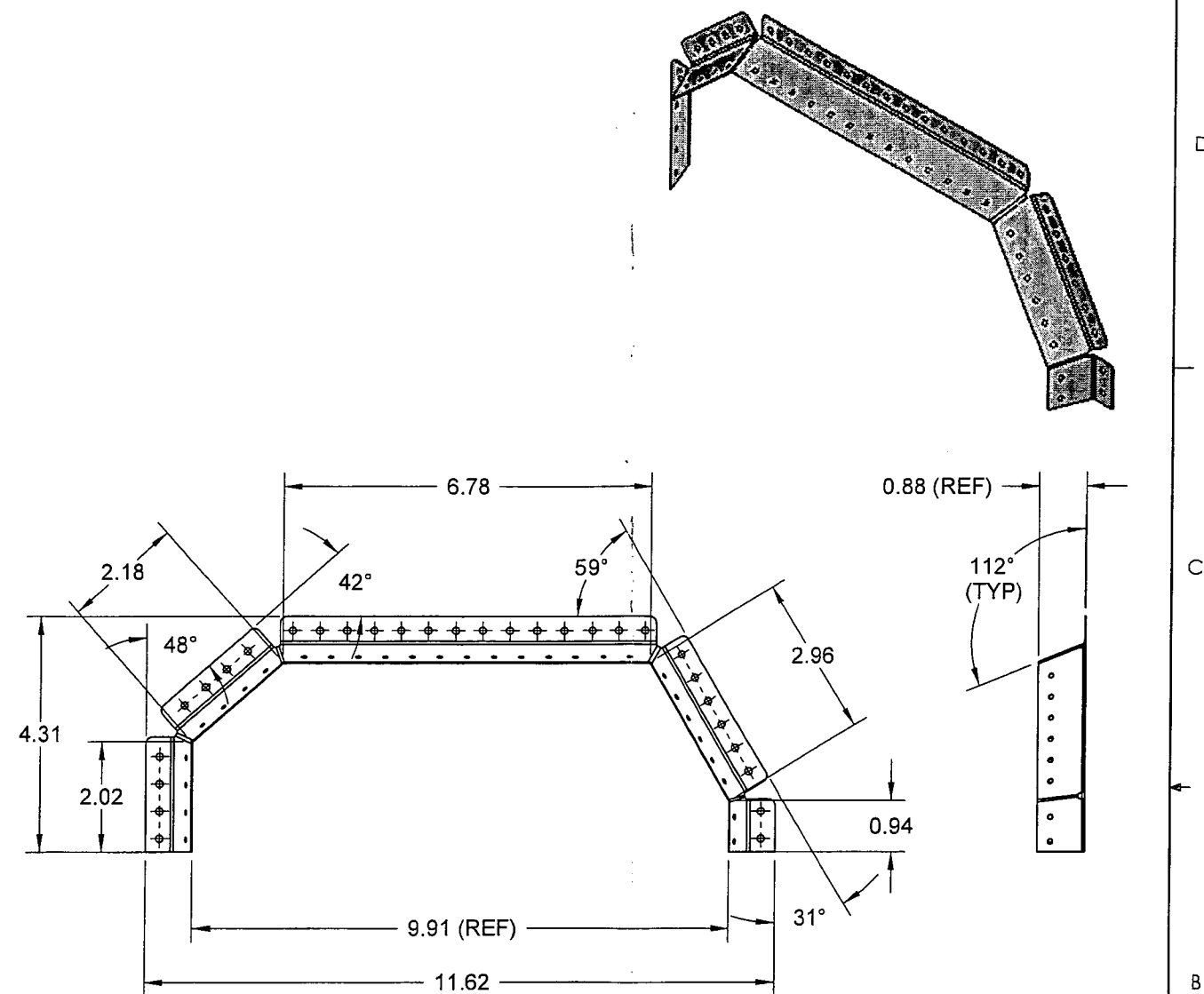
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	LE	DRAWING NO. D3651	REV. B
MFG. APPR.	MA	SHEET 2 OF 9	
APPROVED	MA	TITLE AFT BASE ASSEMBLY	SCALE 1:3
DE APPR.	MA	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.01.07		



D3651-7F FLAT PATTERN 

NOTES:

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs



D3651-7 BOTTOM FLANGE BEND DETAIL 
(MAKE FROM D3651-7F FLAT PATTERN)

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>UE</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>NA</i>	D3651	SHEET 6 OF 9
APPROVED	<i>ND</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	AFT BASE ASSEMBLY	1:3
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